



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

split

D2616-2

Job Sheet 167087



Part No: D2616-2

Job Qty: 2 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 10/27/17

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Customer: Questral Helicopters Ltd (CQUES01)

350 Comet Private, Suite 120 Ottawa, ON, K1V 9B4 Canada ph:(613) 739-3306

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		10/26/17	0.00	0.00	Start Up Machining		
100	Bandsaw	2 pcs		10/26/17	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	2 pcs		10/26/17	0.28	0.99	HAAS 1		
130	QC	2 pcs		10/26/17	0.00	0.00	QC8		
140	HandFinish	2 pcs		10/26/17	0.00	0.04	HandFinish1		
150	Powdercoat	2 pcs		10/26/17	0.00	0.07	Powdercoat3		
160	QC	2 pcs		10/26/17	0.00	0.00	QC3		
170	Small Fab	2 pcs		10/27/17	0.00	0.14	Small Fab		<i>SP</i> <i>DAS</i>
180	QC	2 pcs		10/27/17	0.00	0.00	QC5		<i>38</i>
190	Packaging	2 pcs		10/27/17	0.00	0.00	Packaging3		<i>9-89</i>
200	QC21-SA	2 Ea		10/27/17	0.00	0.00	QC21		<i>165 17-11-01</i>

Part Op 100 - Cut blanks: 2.000" long +0.030" -0.000"

Descriptions: 110 - 1-Machine as per folio D2616-2 & DWG D2616 2-Tumble & Deburr

150 - Note:Mask large hole START TIME: _____

170 - 1-Coat bearing in light oil 2-Press Bearing in D2616-2 3-Stack as per Dwg D2616 using DT8019 4- Touch up paint if required

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.500X01.250	2	0	0	0
170-Small Fab	D2611	2	3	0	0

57138 13 98
F16645

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	0.250inches $\pm$ 0.010	0.260 0.240		
2	Mounting Lug	1.250inches $\pm$ 0.010	1.260 1.240		
3	Mounting Lug	0.375inches $\pm$ 0.010	0.385 0.365		
4	Mounting Lug	0.625inches $\pm$ 0.010	0.635 0.615		
5	Mounting Lug	0.257inches + 0.006 - 0.001	0.263 0.256		
6	Mounting Lug	1.000inches $\pm$ 0.010	1.010 0.990		
7	Mounting Lug	2.000inches $\pm$ 0.010	2.010 1.990		
8	Mounting Lug	1.125inches $\pm$ 0.010	1.135 1.115		
9	Mounting Lug	0.313inches $\pm$ 0.010	0.323 0.303		
10	Mounting Lug	17.000Degrees $\pm$ 0.500	17.500 16.500		
11	Mounting Lug	1.259inches $\pm$ 0.010	1.269 1.249		
12	Mounting Lug	0.250inches $\pm$ 0.010	0.260 0.240		
13	Mounting Lug	0.063inches $\pm$ 0.010	0.073 0.053		
14	Mounting Lug	0.8115inches + 0.0005 - 0.0000	0.8120 0.8115		

Plex 11/1/17 11:12 AM Dart.Gagnon.Michelle



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cmf. Revised. Nov. 1/17.

D2616-2

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Part No: D2616-2

Job Qty: 10 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

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90	Start up Operation	10 Ea		10/26/17	0.00	0.00	Start Up Machining	<i>ML</i>
100	Bandsaw	10 pcs		10/26/17	0.00	0.00	Bandsaw1	<i>ML</i>
110	CNC Vertical Machining	10 pcs		10/26/17	0.28	4.96	HAAS 1	<i>ML</i>
130	QC	10 pcs		10/26/17	0.00	0.00	QC8	<i>ML</i>
140	HandFinish	10 pcs		10/26/17	0.00	0.19	HandFinish1	<i>ML</i>
150	Powdercoat <i>M136370</i>	10 pcs		10/26/17	0.00	0.36	Powdercoat3	<i>BR</i>
160	QC	10 pcs		10/26/17	0.00	0.00	QC3	
170	Small Fab	10 pcs		10/27/17	0.00	0.70	Small Fab	
180	QC	10 pcs		10/27/17	0.00	0.00	QC5	
190	Packaging	10 pcs		10/27/17	0.00	0.00	Packaging3	
200	QC21-SA	10 Ea		10/27/17	0.00	0.00	QC21	

Part Op 100 - Cut blanks: 2.000" long +0.030" -0.000"

Descriptions: 110 - 1-Machine as per folio D2616-2 & DWG D2616 2-Tumble & Deburr

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.500X01.250	10	0	0	0
170-Small Fab	D2611 <i>FM13851598</i>	10	3	0	0

DART
AEROSPACE
S001816

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Mounting Lug

PART NO:
Revision:
Operation:
Quantity:
Change No:

D2616-2

Start up Operation
8

Mfg Date: 10/24/17
Job No: 167087

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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13	Mounting Lug	0.063inches $\pm$ 0.010	0.073 0.053		
14	Mounting Lug	0.8115inches + 0.0005 - 0.0000	0.8120 0.8115		

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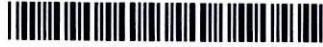
Kush

D2616-2
Job Sheet 166976

Part No: D2616-2

Job Qty: 10 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/20/17

Job Tracking No:

Due Date: 10/27/17

Created By: Mario Poulin

Type: SOLD

Description:

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170	Small Fab	10 pcs		10/27/17	0.00	0.70	Small Fab	
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Job Allocations

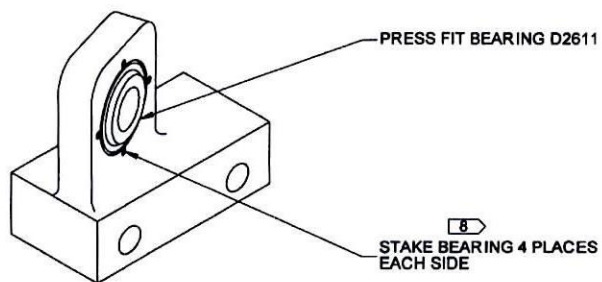
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.500X01.250	10	0	0	0
170-Small Fab	D2611	10	3	0	0

Part Specifications

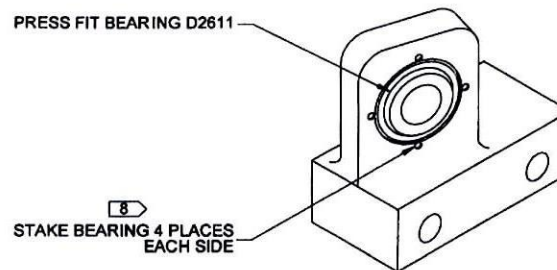
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Plex 10/20/17 2:23 PM dart.poulin.mario



D2616-1 FWD MOUNT LUG



D2616-2 FWD MOUNT LUG

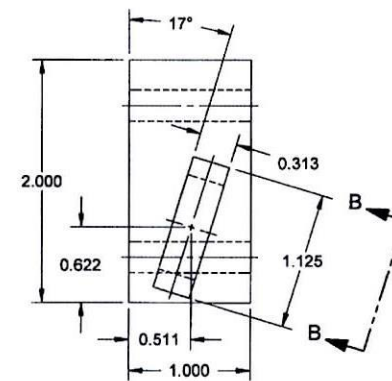
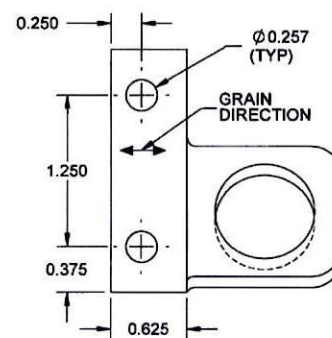
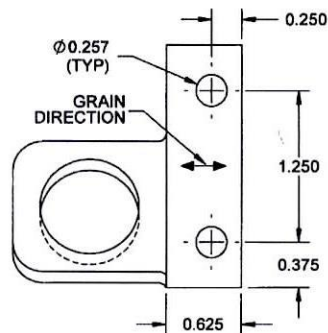
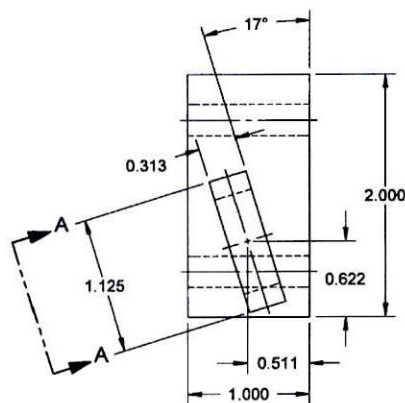
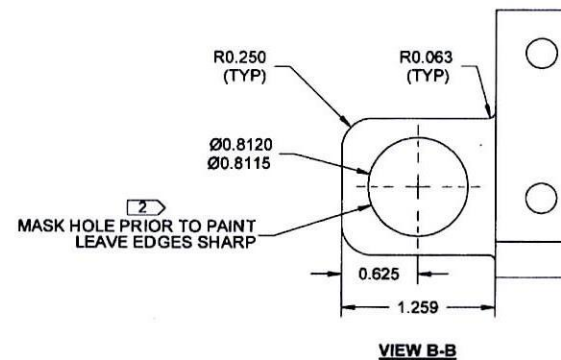
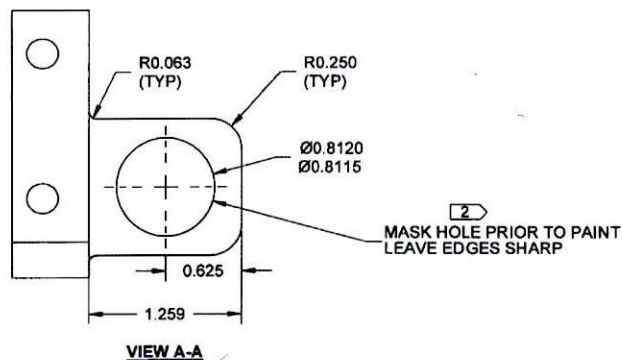
QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.

RELEASED
07.12.12/14

E	UPDATE DWG. SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6-B2	KE	97.07.31
C	REMOVE D2616-3	BW	97.06.04
B	RE-DESIGN	KE	97.05.06
A	ORIGINAL ISSUE	BW	96.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2616	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK BEARING HOLE PRIOR TO PAINT
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
07.12.12

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	MS	D2616	SHEET 2 OF 2
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	FWD MOUNT LUG	1:1
DATE	07.11.22	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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